

Work Order ID 100051

100051

April-17-13 12:38:30 PM

Page 1

Item ID: D4768-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web. Float

Start Date: 4/17/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *130417* Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4768	<i>A</i>

100 0.00

100

Purchasing

Purchasing

Memo

Purchasing

Issue P/O:

19780

Supplier: WEJAY.

Machine as per Dwg D4768-1

Conformity sheet required

0.00

CL 13/05/03 *(B)*

110-

Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

4/30/14 *(6)*

Work Order ID 100051

April-17-13 12:38:30 PM

100051

Page 2

Item ID: D4768-1

Revision ID:

Item Name: Web. Float

Start Date: 4/17/13 Start Qty: 2.00

Required Date: 5/01/13 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				5	1		
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish QC7 Memo	0.00 0.00							

SHP
B-710

→
P70

13-07-12
SAD

13/07/17

Work Order ID 100051

April-17-13 12:38:30 PM

100051

Page 3

Item ID: D4768-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Web. Float

Start Date: 4/17/13 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: LS

0.00

150

Packaging

Memo

0.00

Packaging

5

B 13/07/17

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 13-07-17

MLJ 13-07-17

Picklist Print

April 17/13 12:38:54 PM

Page 1

Work Order ID: 100051

100051

Parent Item: D4768-1

D4768-1

Parent Item Name: Web. Float

Start Date: 4/17/13

Required Date: 5/01/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-04-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4688-1-180		Manufactured	No				Each	28.0000					
D4688-1-180										**		2	
Extrusion 180" Long												CD 13/05/15	

Location

Loc Qty

Loc Code

LG

28

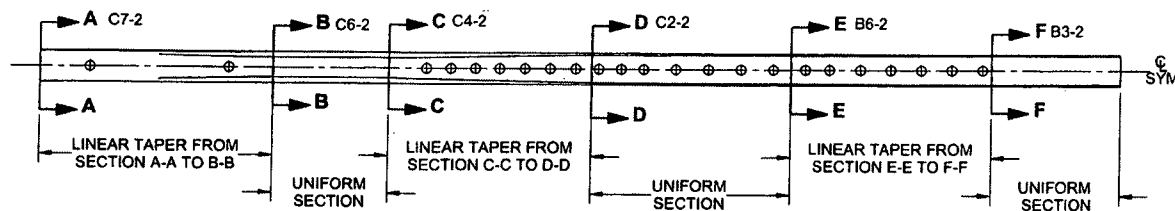
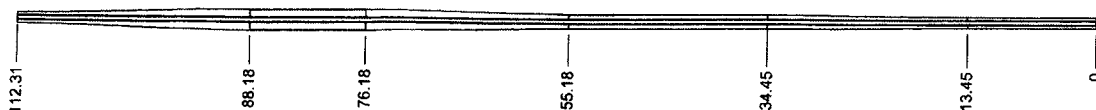
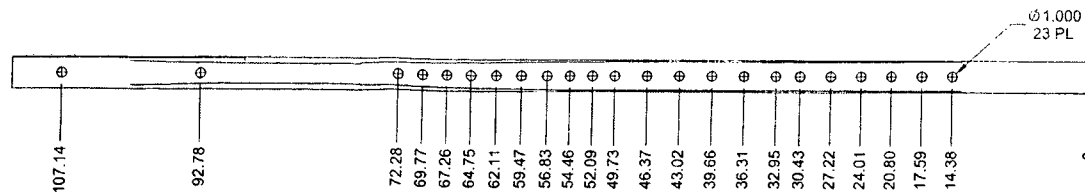
95549

28

6

4/13/13-04-12
D4768-TP

13/2/7 (4)



D4768-1 WEB (FLOAT)

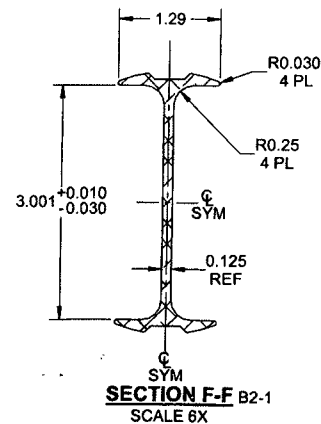
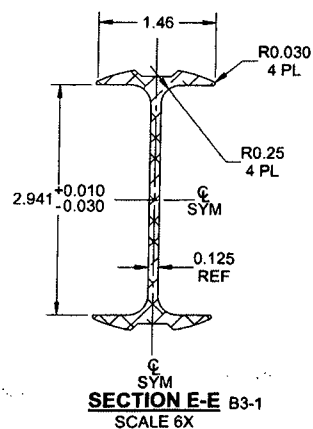
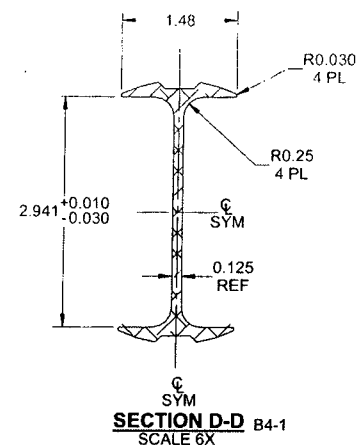
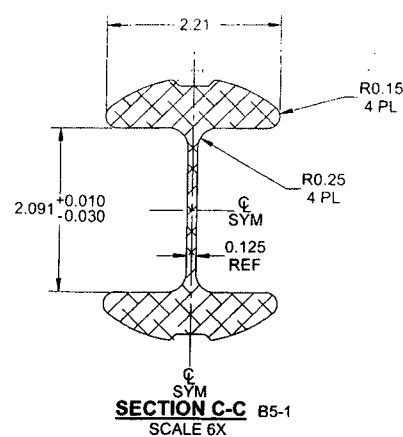
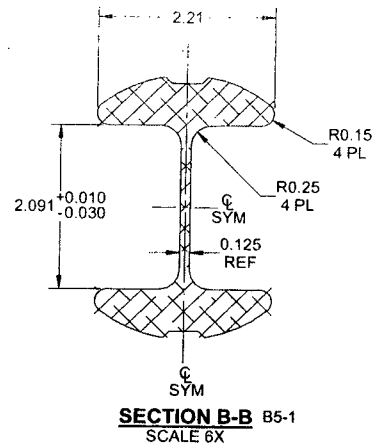
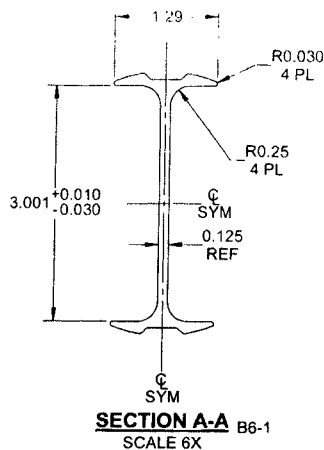
RELEASED
2013-03-25

NOTES:

- 1) MATERIAL: MAKE FROM D4688-1-113 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4768-1" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 13.35 lbs

A NEW ISSUE...		AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4768	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	13.02.13	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

100051



- NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: N/A

RELEASED
 2013-03-25

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4768	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEB	NTS
DATE	13.02.13	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

CUSTOMER: Dart Aerospace

P.O. No. PO19780	DWG No. D4768	REV. A	DESCRIPTION: Float Web	QTY. REC. 6	QTY. REL. 1	JOB/BATCH No. 36305	TRACECODE: -	PAGE: 1 of 3
	PART No. D4768-1P		RESPONSIBILITY: --	LOCATION: Wejay Insp. -Hold		NONCONF. OP. No. --	LAST COMPLETE OP. No. complete	

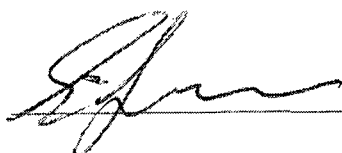
DESCRIPTION OF NONCONFORMANCE

Item	Qty	
1	1	Approx. 11.5" section of 1 flange machined away on one side of web. See photo attached.

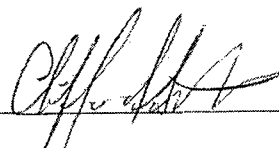
DISPOSITION PROPOSAL

Item Ref.	
1	Scrap.

MFG. SIGNATURE:



INSPECTOR:



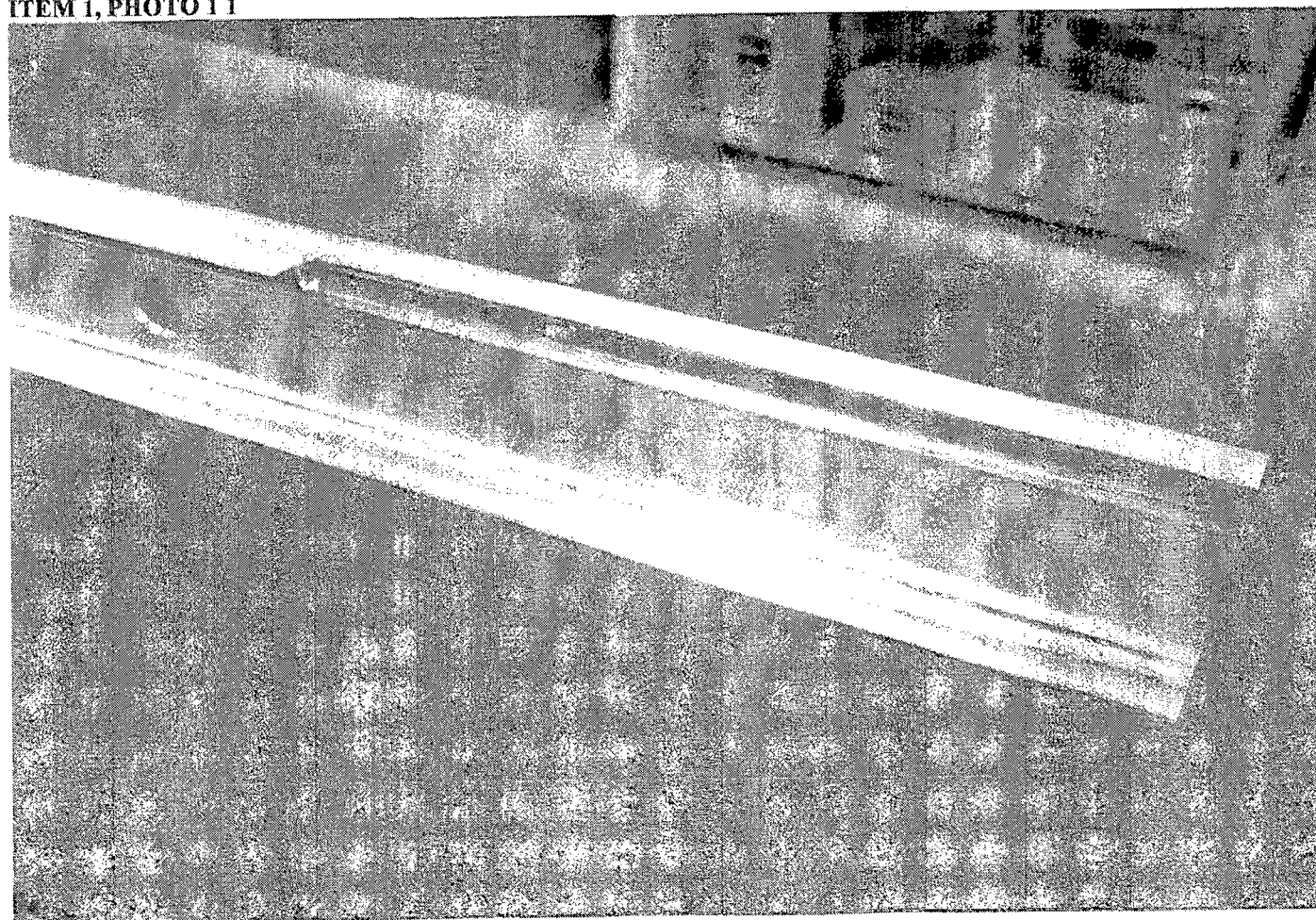
DATE: June 18, 2013

DATE: June 18, 2013

CUSTOMER: Dart Aerospace

P.O. No. PO19780	DWG No. D4768	REV. A	DESCRIPTION: Float Web	QTY. REC. 6	QTY. REL. 1	JOB/BATCH No. 36305	TRACECODE: -	PAGE: 2 of 3
	PART No. D4768-1P		RESPONSIBILITY: --	LOCATION: Wejay Insp. -Hold		NONCONF. OP. No. --	LAST COMPLETE OP. No. complete	

ITEM 1, PHOTO 1 1



NCR: Yes / No

see pink 13-2805

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: dat Date: 13/08/06QA Closed: KA Date: 13/7/19

Work Order: <u>100051</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4768-1</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>13-2805</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	13710	100	1	operation error in route compensation for Datum shift in new program QTY ① scrap R.C. submission	DAS 16 9-89 Q22012 13/7/10	Destroyed part no replace QTY ① \$0	 13-7-10 PL 13-7-12 R 13-7-12	DAS 16 9-89 13/7/10 13-7-12	Q22012 13/7/10
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

CUSTOMER: Dart Aerospace

P.O. No. PO19780	DWG No. D4768	REV. A	DESCRIPTION: Float Web	QTY. REC. 6	QTY. REJ. 1	JOB/BATCH No. 36305	TRACECODE: -	PAGE: 3 of 3
PART No. D4768-1P		RESPONSIBILITY: --		LOCATION: Wejay Insp. -Hold		NONCONF. OP. No. --		LAST COMPLETE OP. No. complete

ISSUED TO: Ed Jansen

DEPARTMENT: Production

Note: To be completed & returned to Quality Assurance within 5 working days.

CAUSE OF NONCONFORMANCE

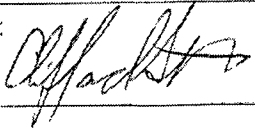
Item Ref.	
1	Operator error. Incorrect compensation for Datum Shift in new program (1st part).

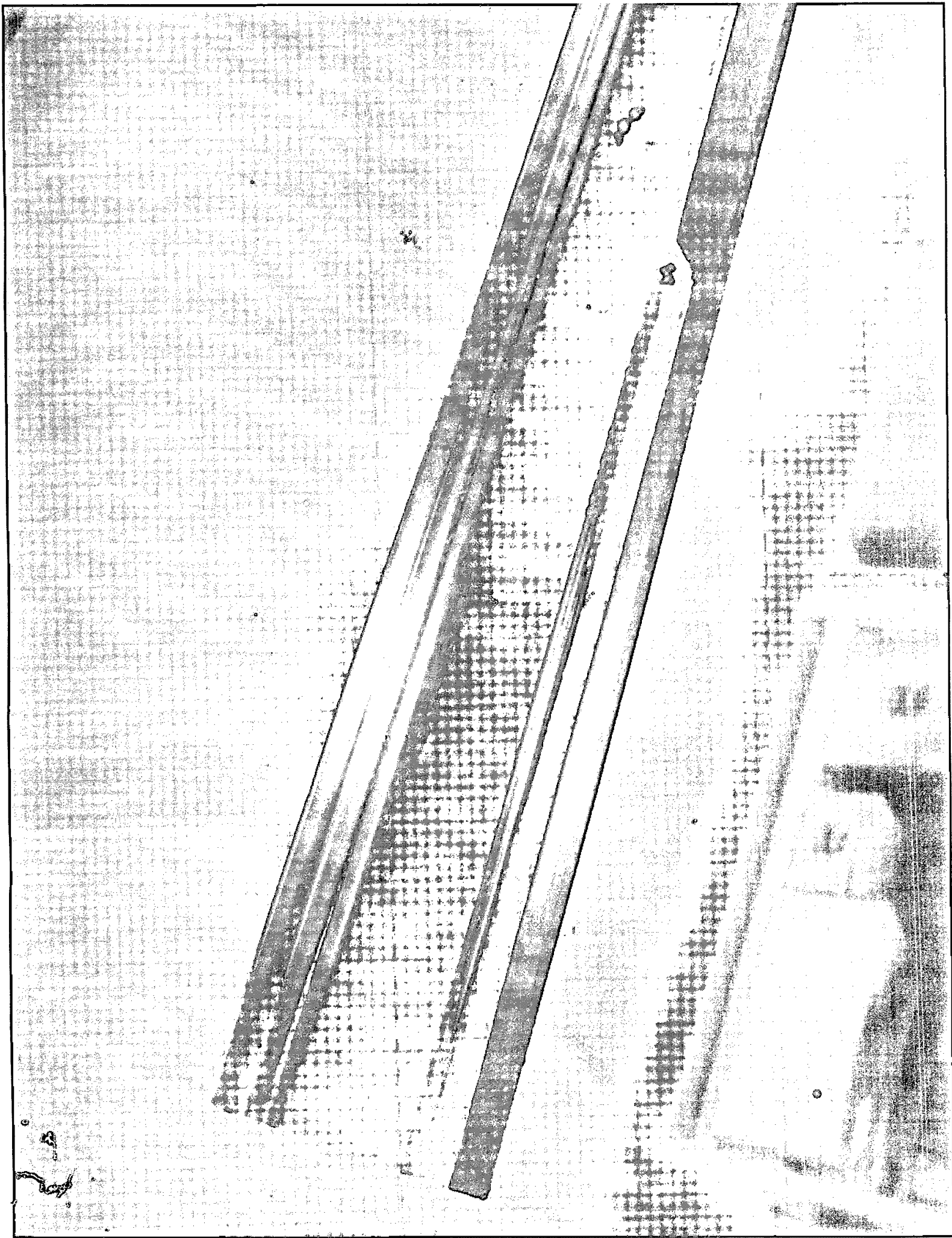
CORRECTIVE ACTION

Item Ref.	
1	Eliminate bugs/ errors in program to avoid reoccurrence of machine error on remaining and future parts.

CUSTOMER DISPOSITION

Item Ref.	

CORRECTIVE ACTION		FOLLOWUP: CORRECTIVE ACTION HAS BEEN IMPLEMENTED AND VERIFIED AS EFFECTIVE.	
ACCEPTED: <input checked="" type="checkbox"/> NOT ACCEPTED: <input type="checkbox"/>		Q.A. MANAGER: DATE:	
Q.A. MANAGER:  DATE: June 18, 2013		Q.A. MANAGER: DATE:	





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19780

Purchase Order Date 5/3/2013

PO Print Date 5/15/2013

Page Number 1 of 1

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

613-384-1662

Requisition Nbr

Vendor Fax

613-384-2997

Tax Resale Nbr

10127-2607

Vendor Account Nbr

Terms

COD

Currency

CAD

FOB

Destination-Collect

FILED
5/13/2013

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

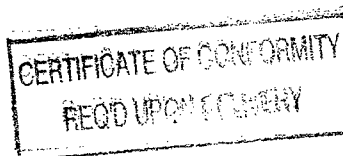
REVISED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4768-1P	Web, Float	5/31/2013 Yes	6.00 Each	Day & Ross coll	\$550.0000	\$3,300.00

Special Inst: AS PER DWG D4768 REV. A
B100051

PO Total:

\$3,300.00



Change Nbr:

2

Change Date: 5/15/2013

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required (YES) NO



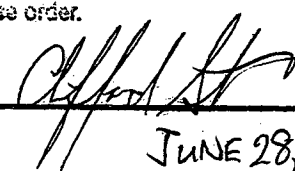

Packing Slip 36305

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

INVOICE DATE	YOUR ORDER NO. PO19780	DATE ORDERED 05/15/13	SHIPPED VIA Best way
CUSTOMER CODE DART	PROV. LIC. NO.	Extra <input type="checkbox"/> Exempt <input type="checkbox"/>	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
0		6	Machine web, float as per drawing D4768, Rev. A B100051 D4768-1P <u>NOTE: 1 PART TAGGED AS SCRAP - TO BE REPLACED ON FUTURE ORDER.</u>		
<p align="center">RELEASE NOTE</p> <p>I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>Inspection Supervisor   JUNE 28, 2013</p>					
				G.S.T.	
				P.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: June 28, 2013	
		P.O.# PO19780	
		WEJAY JOB# 36305	
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4768-1P 'Float Web' Batch# B100051	5	Machined complete per drawing req'ts.	D4768 / rev. A
D4768-1P 'Float Web' Batch# B100051	1	Machined complete - rejected as per NCR# 0137	D4768 / rev. A
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36305

PAGE: 1 of 2

CUSTOMER: Dart Aerospace

CUST. P.O.# PO19780

PART No. D4768-1

DESCRIPTION: Float Web

DWG No. D4768

REV. A

E.C.O. -

MATERIAL: D4688-1-113 Extrusion - supplied by DAS

INSPECTOR

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# -

DATE

JUNE 17, 2013

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC (inches)	DETAILS	TOLERANCE (Per DART QSI 018)	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Ø1.000 hole thru	23 places	+0.010/-0.001		✓	1	Acc.
2	14.38		±.03		✓	1	h
3	17.59		±.03		✓	1	h
4	0.80		±.03		✓	1	h
5	24.01		±.03		✓	1	h
6	27.22		±.03		✓	1	h
7	30.43		±.03		✓	1	h
8	32.95		±.03		✓	1	h
9	36.31		±.03		✓	1	h
10	39.66		±.03		✓	1	h
11	43.02		±.03		✓	1	h
12	46.37		±.03		✓	1	h
13	49.73		±.03		✓	1	h
14	52.09		±.03		✓	1	h
15	54.46		±.03		✓	1	h
16	56.83		±.03		✓	1	h
17	59.47		±.03		✓	1	h
18	62.11		±.03		✓	1	h
19	64.75		±.03		✓	1	h
20	67.26		±.03		✓	1	h
21	69.77		±.03		✓	1	h
22	72.28		±.03		✓	1	h
23	92.78		±.03		✓	1	h
24	107.14		±.03		✓	1	h
25	112.31	O.A. length	±.03		✓	1	h
26	1.29 typ.	Section A-A	±.03		✓	1	h
27	3.001		+0.010/-0.030		✓	1	h
28	R0.025 4 pl.		±.03		✓	1	h

INSPECTION / TEST REPORT

JOB No. 36305

PAGE: 2 of 2

CUSTOMER: Dart Aerospace

CUST. P.O.# PO/9780

PART No. D4768-1

DESCRIPTION: Float Web

DWG No. D4768

REV. A

E.C.O. -

REF. No.	CHARACTERISTIC (inches)	DETAILS	TOLERANCE (Per DART QSI 018)	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
----------	-------------------------	---------	------------------------------	--------------	--------	------------	---------------------------------

29	R0.030 4 pl.	Section A-A cont'd	±.03		✓	1	Acc.
30	2.21 typ.	Section B-B	±.03		✓	1	h
31	2.091		+0.010/-0.030		✓	1	b
32	R0.15 4 pl.		±.03		✓	1	n
33	R0.25 4 pl.		±.03		✓	1	n
34	1.48	Section C-C	±.03		✓	1	n
35	2.091		+0.010/-0.030		✓	1	b
36	R0.15 4 pl.		±.03		✓	1	n
37	R0.25 4 pl.		±.03		✓	1	n
38	1.48 typ.	Section D-D	±.03		✓	1	n
39	2.941		+0.010/-0.030		✓	1	n
40	R0.03 4 pl.		±.03		✓	1	n
41	R0.25 4 pl.		±.03		✓	1	n
42	1.46 typ.	Section E-E	±.03		✓	1	n
43	2.941		+0.010/-0.030		✓	1	n
44	R0.03 4 pl.		±.03		✓	1	n
45	R0.25 4 pl.		±.03		✓	1	n
46	1.29 typ.	Section F-F	±.03		✓	1	n
47	3.001		+0.010/-0.030		✓	1	n
48	R0.03 4 pl.		±.03		✓	1	n
49	R0.25 4 pl.		±.03		✓	1	n
50	Deburring	Per note 5	.005-.010		✓	1	n

